



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D4131-043
Job Sheet 176980



Part No: D4131-043

Job Qty: 6 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/7/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		5/7/18	0.00	0.00	Start Up Waterjet		SA 8/15/04
100	Waterjet	6 pcs		5/7/18	0.00	0.67	Waterjet1		SA 8/15/04
120	QC	6 pcs		5/7/18	0.00	0.00	QC8		38
130	Small Fab	6 pcs		5/7/18	0.00	0.38	Small Fab-6		38
150	QC	6 pcs		5/7/18	0.00	0.00	QC5		38
160	HandFinish	6 pcs		5/7/18	0.00	0.34	HandFinish1		SA 18-09-14
161	QC	6 pcs		5/7/18	0.00	0.00	QC7-3		38
165	Small Fab	6 pcs		5/7/18	0.00	0.38	Small Fab-6		38
166	QC	6 pcs		5/7/18	0.00	0.00	QC5		38
180	Packaging	6 pcs		5/7/18	0.00	0.00	Packaging3-2		5/10/18
190	QC21-SA	6 Ea		5/7/18	0.00	0.00	QC21		MAY 16 2018

Part Op 100 - 1-Cut D4131-7 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr as required
 Descriptions: 130 - COUNTER SINK AS PER DWG Deburr if necessary.
 165 - ASSEMBLE NUT PLATES AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	1.0842 sf (.1807 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	48 Ea (8 ea)	165-Small Fab	5018535
MS21069L3	Anchor Nut	24 Ea (4 ea)	165-Small Fab	5050044

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	1	181	0
165-Small Fab	MS20426AD3-3	48	4,948	0
	MS21069L3	24	218	0



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Container No: S068668



Part: D4131-043

Job No: 176980

Serial No/Batch: S068668

Revision:
Inspector:

Date: 05/04/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	0.099	Diameter
2	Doubler Assembly	0.191Inches + 0.005 - 0.001	0.196 0.190	0.192	Diameter
3	Doubler Assembly	0.250Inches ± 0.010	0.260 0.240	0.250	
4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490	0.501	
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0.407	
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0.406	
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560	0.599	
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630	0.666	
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610	3.641	
10	Doubler Assembly	4.000Inches ± 0.010	4.010 3.990	3.999	
11	Doubler Assembly	4.100Inches ± 0.030	4.130 4.070	4.10	
12	Doubler Assembly	4.810Inches ± 0.030	4.840 4.780	4.818	
13	Doubler Assembly	4.600Inches ± 0.010	4.610 4.590	4.604	
14	Doubler Assembly	5.410Inches ± 0.030	5.440 5.380	5.411	
15	Doubler Assembly	0.063Inches ± 0.010	0.073 0.053	0.060	

Plex 5/3/18 3:05 PM Dart. Gagnon. Michelle